

Date: Friday, 12/12/2008 8:07:47 AM
 User: Jean-Luc Menard

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SUPPORT |
| Job Number | : 44033 | | |
| Estimate Number | : 10462 | | |
| P.O. Number | : | Part Number | : D32782 |
| This Issue | : 12/12/2008 S.O. No. : | Drawing Number | : D3278 REV. C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 11 Type : MACHINED PARTS | Drawing Revision | : C |
| Previous Run | : 43418B | Material | : |
| Written By | : <u>JP 08.12.12</u> | Due Date | : 19/12/2008 Qty: 40 Um: Each |
| Checked & Approved By | : | | |
| Comment | : Est A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1000X02000 | 6061-T6 Bar 1.00 x 2.00 |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.2454 f(s)/Unit Total: 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: M110167

JL 08/12/18

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



(40)

Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

JL 08/12/18

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

JIT 08/12/21

(40)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



(40)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JIT 08/12/21

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



(40)

Comment: SECOND CHECK

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 44033

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



40X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1 08/12/30

7.0

POWDER COATING

POWDER COATING



M 10999 6



40X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320 OF
11:30

M-1 08/12/30

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT

FL 08/12/30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



40X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8/12/31

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

09/01/05

Job Completion



08-01-05

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 44033 |
| Description: Support | | Part Number: D3278-2 |
| Inspection Dwg: D3278 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

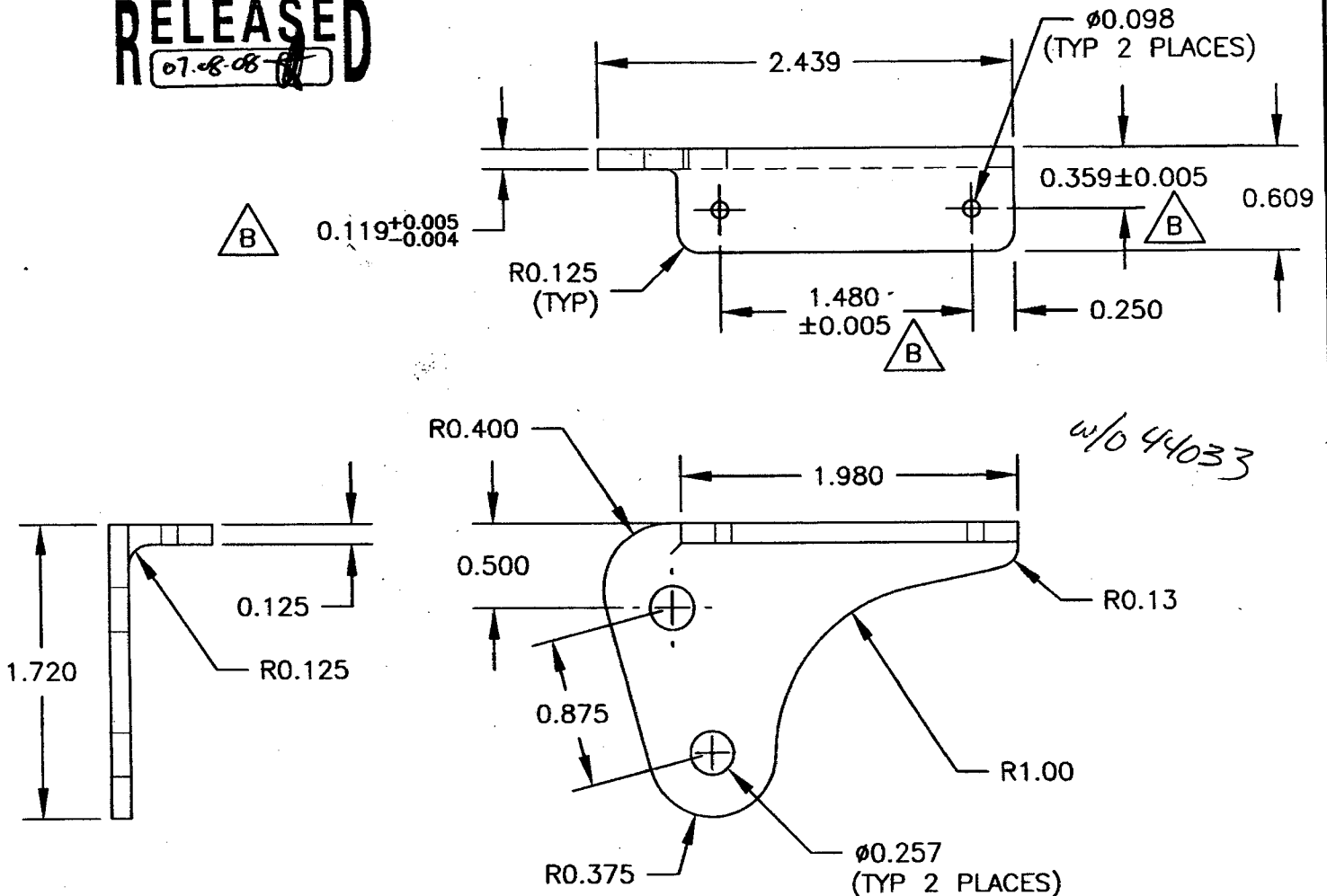
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | 0.099 | ✓ | | | |
| 0.359 | +/-0.005 | 0.355 | ✓ | | | |
| 0.609 | +/-0.010 | 0.6135 | ✓ | | | |
| 0.250 | +/-0.010 | 0.248 | ✓ | | | |
| 1.480 | +/-0.005 | 1.477 | ✓ | | | |
| R0.125 | +/-0.010 | 0.125 | ✓ | | | |
| 0.119 | +0.005/-0.004 | 0.119 | ✓ | | | |
| 2.439 | +/-0.010 | 2.440 | ✓ | | | |
| | | | | | | |
| 1.980 | +/-0.010 | 1.981 | ✓ | | | |
| R0.13 | +/-0.030 | 0.130 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | 0.260 | ✓ | | | |
| R0.375 | +/-0.010 | 0.375 | ✓ | | | |
| 0.875 | +/-0.010 | 0.875 | ✓ | | | |
| 0.500 | +/-0.010 | 0.499 | ✓ | | | |
| R0.400 | +/-0.010 | 0.400 | ✓ | | | |
| R1.00 | +/-0.030 | 1.00 | ✓ | | | |
| | | | | | | |
| 1.720 | +/-0.010 | 1.723 | ✓ | | | |
| R0.125 | +/-0.010 | 0.125 | ✓ | | | |
| 0.125 | +/-0.010 | 0.128 | ✓ | | | |
| | | | | | | |

| | | | |
|-------------------------|-----------------------|----------------------------|-----|
| Measured by: DJP | Audited by: JL | Prototype Approval: | N/A |
| Date: 08/12/21 | Date: 08/12/23 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |
| C | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC | |

DART

| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>SC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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